

# Work Order ID 55535



Page 1

January 19, 2010 3:47:25 PM

Item ID: D4054-003

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 1/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

*PL*

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4054

A

0.00

(6X)

100



Small Fab

Small Fab

Memo

0.00

Bend tube as per Dwg D4054

with ~~eff~~  
DT9576  
5

=7 M.L

10/01/25

PL →

110



QC5- Inspect part completeness to step on W/O

0.00

→ Sub 01/25

(x6)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4054-003 PAR #: \_\_\_\_\_ Fault Category: Small Fails NCR: Yes  DQA:  Date: 10-01-28

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 55535		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/21	100	Scrap 2 length becomes new Template D3298-003 for new revision D4054-003	J RSIW2	Scrap - destroy No replace	S 10/01/21	S 10/01/21	J RSIW2	S 10/01/21
		R.C. Process/ <del>make</del> while making New templates.	J RSIW2	_____	_____	_____	J RSIW2	S 10/01/21

NOTE: Date & initial all entries

# Work Order ID 55535

January 19, 2010 3:47:25 PM



Page 2

Item ID: D4054-003

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 1/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

120



Packaging

Packaging

Operation  
Description

Identify as per dwg & Stock Location: 196

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

(b-1-26)

(6x) SL

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/2010

MF  
10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

January 19, 2010 3:47:29 PM

Work Order ID: 55535



Parent Item: D4054-003



Parent Item Name: Tube Assembly

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	128.1400	12.2526			

6061-T6 RD Tube .500 x.049W



Warehouse                    Loc Qty                    Loc Code

Location

Main Warehouse

MAT

128.14

m-f 10/01/21

111028

37.53

12.2526

111944 ✓

90.61

MS20819-8A  
Sleeve

qty 2      Batch: M112612

12 X      m-f 10/01/21 \*

AN818-8A  
Nut

qty 2      Batch: M112492  
                M113422

10X      m-f 10/01/21 \*

2X      m-f 10/01/21 \*

10.01.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B 55535

DART AEROSPACE LTD	Work Order:	DT9576
Description: Tube Assembly	Part Number:	D4054-003
Inspection Dwg: D4054-003 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>M. H.</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10/01/21	Date:	10/01/21		Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

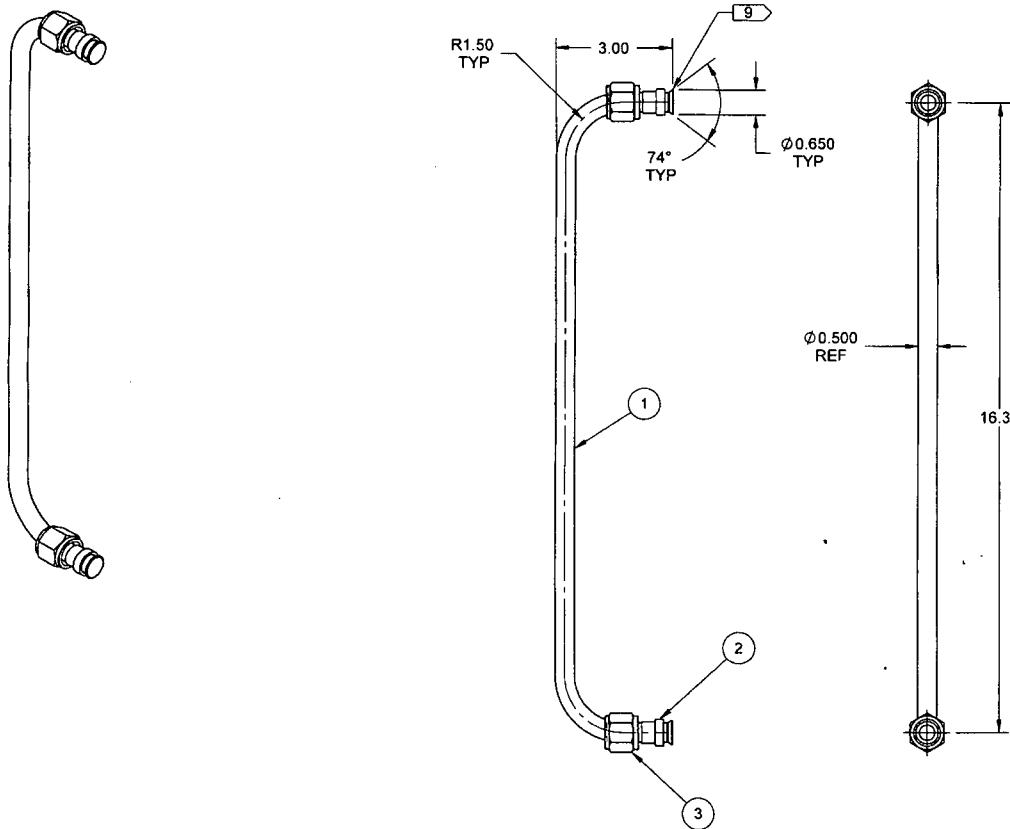
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\*NOTE: Date & initial all entries

ITEM NO.	QTY -001	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT

SHOP COPY  
RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55535  
2010-1-19

RELEASED  
2010-01-14  
MMP



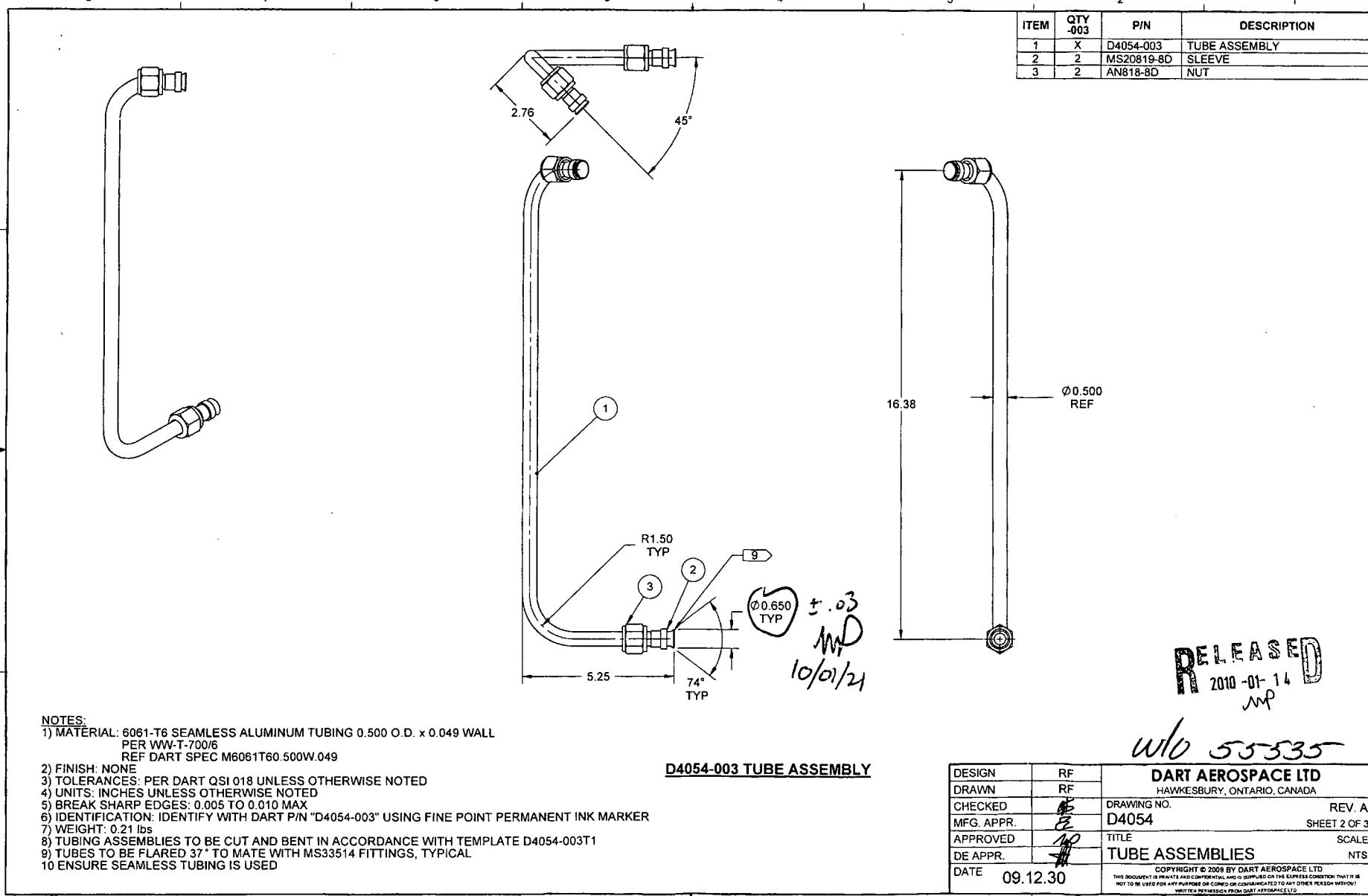
D4054-001 TUBE ASSEMBLY

NOTES:

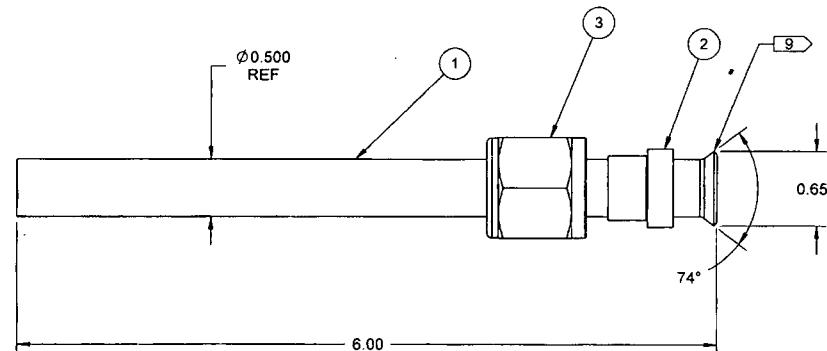
- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL PER WW-T-700/6 REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

A	NEW ISSUE	RF	09.12.30
REV.	DESCRIPTION		BY
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>E</u>		
MFG. APPR.	<u>E</u>		
APPROVED	<u>RP</u>	DATE	REV. A
DE APPR.	<u>RP</u>	DRAWING NO.	SHEET 1 OF 3
DATE	09.12.30	D4054	
TITLE			
SCALE			
NTS			
TUBE ASSEMBLIES			
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ITEM	QTY -003	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



ITEM	QTY -009	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



D4054-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL  
PER WV-T-700/6  
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>EZ</i>	D4054	SHEET 3 OF 3
APPROVED	<i>AG</i>	TITLE	SCALE
DE APPR.	<i>AG</i>	TUBE ASSEMBLIES	
DATE	09.12.30	NTS	

*w/o 55535*

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8 7 6 5 4 3 2 1

RELEASED  
R 2010-01-14  
*MP*

A

D

C

B

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